



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3701-00
Job Sheet 170589



Part No: RBE350A94-3701-00

Job Qty: 6 ea

Part Name: Main Rotor Rigging Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 2/27/18

Type: Stock

Description:

Note: DWG RBE350A94-3701-00 REV: 2A IPP REV: A 18.01.15 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/27/18	2/27/18	0.00	0.00	Small Fab-9	Start up 4/1/12	de 18/02/05
100	Waterjet	6 pcs	2/27/18	2/27/18	0.00	0.20	Waterjet 2 OMAX		de 18/02/05
110	QC	6 pcs	2/27/18	2/27/18	0.00	0.00	QC2 Waterjet-3		de 18/02/05
140	QC	6 pcs	2/27/18	2/27/18	0.00	0.00	QC5		38
170	Outsource	6 pcs	2/27/18	2/27/18	0.00	0.00	Outsource4		AT 18/02/23
180	Packaging	6 pcs	2/27/18	2/27/18	0.00	0.00	Packaging2		AT 18/02/23
190	QC	6 pcs	2/27/18	2/27/18	0.00	0.00	QC6		38
200	Packaging	6 pcs	2/27/18	2/27/18	0.00	0.00	Packaging3		9-89
210	QC21-FG	6 Ea	2/27/18	2/27/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary

Descriptions: 140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - BLACK ANODIZE PER MIL-A-8625 TY II CL 2

180 - Receive

200 - Identify and Stock

FEB 14 2018

DAS
21
9-89

MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	6 sf (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:30 AM Dart.lajeunesse.marie

DART
AEROSPACE

S039622



Main Rotor Rigging Tool

ART NO:
Original Serial #:
Revision:
Operation:
Storage No:

RBE350A94-3701-00

S039622

Start up Operation
02/06/18
Job No: 170589

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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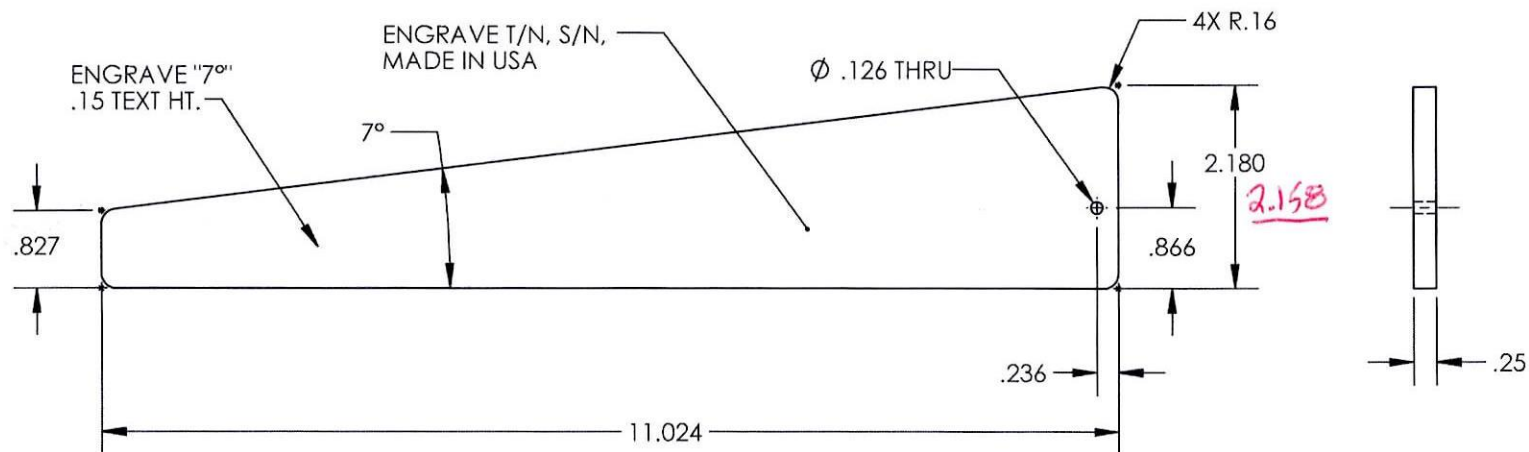
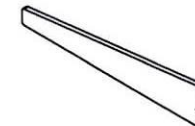
Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGN PER HELI PRODUCTS TOOLS.	9/22/2009	WP	DW
2		THICKNESS CHD FROM .125 TO .25.	3/17/2010	WP	RW
2A		CORRECTED T/N WAS RBEA94-3701-00 IS RBE350A94-3701-00.	11/7/2013	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170589 MCT
1801-19



DART AEROSPACE	
TITLE M/R RIGGING TOOL	
DWG NO. RBE350A94-3701-00	REV 2A
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weid</i>
.XX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	EUROCOPTER AS350/355
SCALE 1:2	DATE 9/22/2009 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	RIGGING TOOL	6061		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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PURCHASE ORDER PO039040

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	171201	647.3917	Doubler Issue P/O to ATG : HARD ANODIZE, COLOR BLACK, AND PRIME AS PER DWG 647.3900 REV. C	Firmed	2/21/18	8 pcs	0 pcs	8 pcs	\$8.01/pcs	\$64.08
6	171214	649.5213	Doubler ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	2/21/18	5 pcs	0 pcs	5 pcs	\$7.86/pcs	\$39.30
7	169390	647.7822	Eye Bolt Fitting RH Issue P/O to ATG : 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	2/21/18	15 pcs	0 pcs	15 pcs	\$10.41/pcs	\$156.15
8	170589	RBE350A94- 3701-00	Main Rotor Rigging Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94- 3701-00 Rev. 2A -Certificate of Conformity is required	Firmed	2/21/18	20 pcs	0 pcs	20 pcs	\$6.61/pcs	\$132.20
	171677			Firmed	2/21/18	2 pcs	20 pcs	2 pcs	\$6.61/pcs	\$13.22
Sub Total:						22	0	22		\$145.42
9	170065	RBT18713-1	Body -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBT18713-1 Rev. 4 -Certificate of Conformity is required	Firmed	2/21/18	13 pcs	0 pcs	13 pcs	\$5.13/pcs	\$66.69
10	171523	RBWSI-HT- 12AS-1	Top -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant	Firmed	2/21/18	10 pcs	0 pcs	10 pcs	\$5.13/pcs	\$51.30



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: RBWSI-HT-12AS-1 Top Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22551		Rev: E PO: PO039040 Line: 10
18 ea	Part: RBE350A94-3700-C-05 Bottom Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22552		Rev: 6 PO: PO039040 Line: 11
6 ea	Part: RBE703A95-0508-00-1 Quill Anodize per MIL-A-8625F, Type II, Class 2, Color, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22553		Rev: 5C PO: PO039040 Line: 12
4 ea	Part: T-8812187000 Drain Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22554		Rev: PO: PO039040 Line: 13
22 ea	Part: RBE350A94-3701-00 Main Rotor Rigging Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22549		Rev: 2A PO: PO039040 Line: 8
13 ea	Part: RBT18713-1 Body		Rev: 4
Made in Canada.			



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Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	Anodize per MIL-A-8625F, Type II, Class 2, red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22550 PO: PO039040 Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.	